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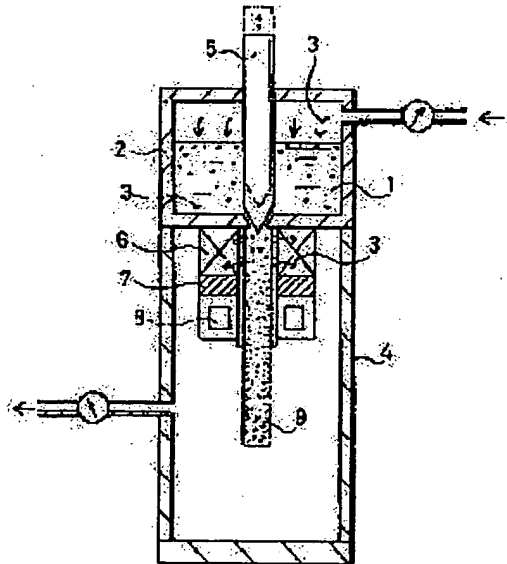
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(54) PRODUCTION OF BILLET FOR THIXOCASTING

(57)Abstract:

PURPOSE: To provide a billet having uniform and fine metallurgical structure by quickly discharging inert gas absorbed into a molten metal in a vacuum chamber, thereafter, forming it to bar-columnar shape in cooling.

CONSTITUTION: Inert gas 3 such as nitrogen in a gas pressurizing chamber 2 is absorbed and dissolved into the molten metal 1 of aluminum or alloy thereof, etc. Successively, the molten metal 1 containing large quantity of the inert gas is poured in the vacuum chamber 4. Then, the inert gas 3 dissolved in the molten metal 1 is quickly discharged with a gas venting part 6 in the vacuum chamber 4, and the molten metal 1 is vigorously stirred by a bubbling phenomenon at this time. Thus, the structure of the molten metal 1 becomes the metallurgical structure fine, uniform and being non-dendrite. Therefore, the molten metal 1 is formed to the bar-columnar shape by passing through a continuous casting mold 7 and cooled and solidified through a cooling part 8 as it is, to make the billet 9. Therefore, the inert gas, etc., in the vacuum chamber 4 is discharged to the outer part through a gas exhaust hole.



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(54)【発明の名称】 チクソキャスト用ビレットの製造方法

(57)【要約】

【目的】 比較的に簡単な装置でもって均一で微細な金属組織を持ったビレットを製造することが出来るチクソキャスト用ビレットの製造方法の提供。

【構成】 溶湯1に不活性ガス3を吸収させた後、該溶湯1中に溶存している不活性ガスを真空チャンバ4内で急激に放出せしめ、その後冷却しつつ棒柱状に成形するようにした。

